

Date: Thursday, 11/29/2007 11:04:33 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 36031	
Estimate Number : 10834	
P.O. Number :	Part Number : D29332
This Issue : 11/29/2007 S.O. No. :	Drawing Number : D2933 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34616	Material :
Written By : <u>HA071129</u>	Due Date : 12/15/2007 Qty: 6 Um: Each
Checked & Approved By : <u>HA071129</u>	
Comment : Est: B 00-06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: B 34872

2F 08/03/19 (6)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

2F 08/03/19

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

2F 08/03/19

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

2F 08/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:04:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 36031

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/03/27

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR

08-03-25

(6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107005

m-k

08/03/25

(6x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-26

(x6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 428A

8/3/26 54

(CA)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

(6)

Job Completion



m-k

08-03-27

(6)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36031
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.123	.123	.123	.123		
B	0.100	0.140		.123	.123	.123	.123		
C	0.100	0.140		.125	.125	.125	.124		
D	0.210	0.230		.222	.219	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.236	.236	.236	.256		
N	0.100	0.140		.119	.119	.119	.119		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.505	.505	.505	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.130	1.130	1.130	1.130		
Y	1.565	1.585	DT8695 A/B	1.570	1.570	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RF
Date:	08/03/19

Audited by:	SN
Date:	08/03/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 36031
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

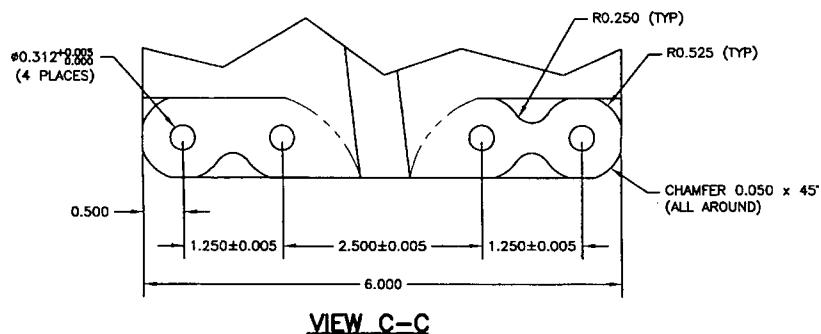
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.123	.123				
B	0.100	0.140		.123	.123				
C	0.100	0.140		.125	.125				
D	0.210	0.230		.222	.222				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.578	1.578				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.236	.236				
N	0.100	0.140		.118	.118				
O	0.540	0.560		.545	.550				
P	0.490	0.510		.503	.501				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.495	2.495				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.370	1.370				
W	0.316	0.321		.321	.321				
X	1.125	1.145		1.130	1.130				
Y	1.565	1.585	DT8695 A/B	1.570	1.570				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>
Date: <i>08/03/19</i>

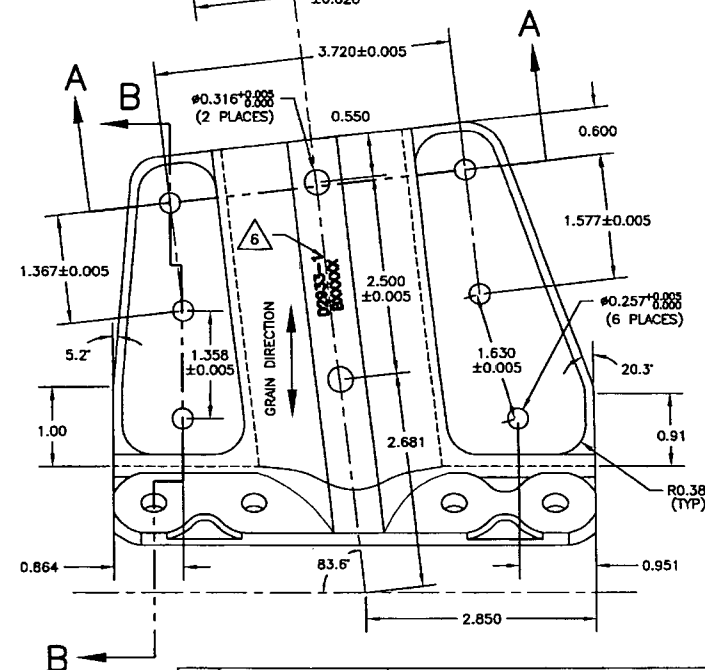
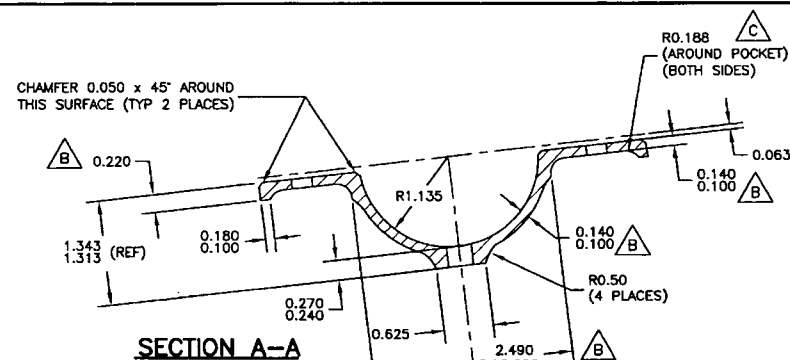
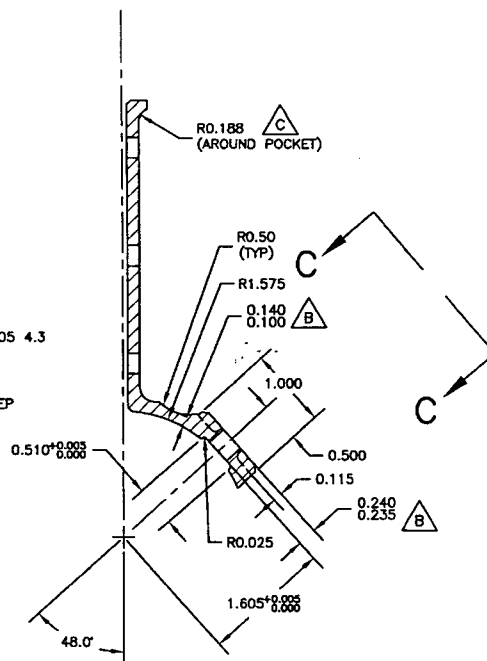
Audited by: <i>SA</i>
Date: <i>08/03/24</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JA</i>	<i>SA</i>



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	TITLE	SADDLE INSIDE
06.11.09		SCALE 2:3

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 07.02.12